

S261728



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

POSITIVE RECALL
EFFECTIVE 20/03/03 AUTH. *Sty*
DAS
RELEASED 55 - BATMAR 1.0 2020
9-89

D5787-3

Job Sheet 207471



Part No: D5787-3

Job Qty: 12 pcs

Part Name: Placard



Part Weight: 0 lbs

Job Created: 2/26/20

Due Date: 3/27/20

Type: Stock

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

Priority: Medium

Note: URF 2020-525 DWG 5787 REV.A IPP REV:A NEW ISSUE 20.31.01 JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Waterjet - Flow - 1	12 pcs	3/27/20	3/27/20	0.17	1.50	Waterjet - Flow		
100	NV5000 - 1 - B4B	12 pcs	3/27/20	3/27/20	1.00	1.00	NV5000 - 1 - B4B		20/03/09
							NV5000 - 2 - B4B		ALA 20/03/10
110	QC 2	12 pcs	3/27/20	3/27/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

DAS
86
9-89

20/03/10



120 QC 8 12 pcs 3/27/20 0.00 0.00

See Pat Duval or Nazim
Acceptable to
stock, but not ship
NO 20.05.18

DAS
55
9-89

MAR 10 2020

QC 2 - 64

QC 2 - 65

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

QC 2 - 76

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

QC 8 - 76

QC 8 - 61

20/03/10

130 Packaging 3-1 - Stock - B4B 12 pcs 3/27/20 0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

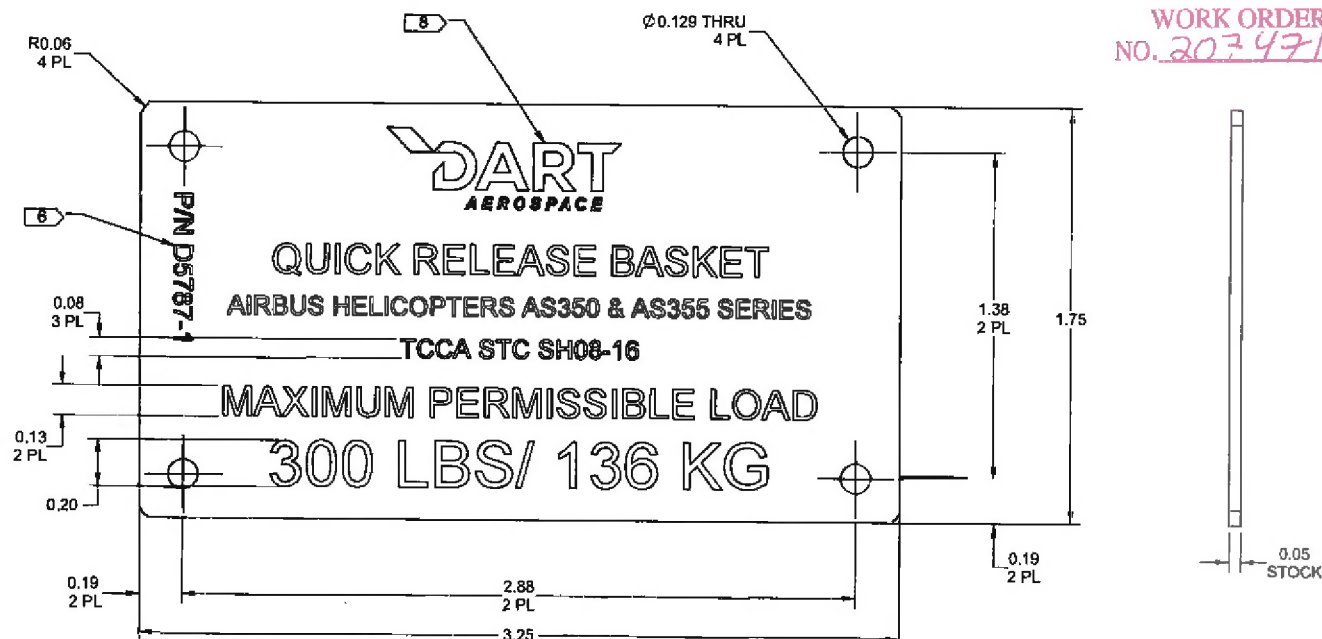
DAS
28
9-89

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	12 pcs	3/27/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 90 - ****ONE BLANK MAKES 3 PARTS**** 1-Cut blank 2-Debur if necessary Descriptions: 100 - 1-Machine as per folio FD167 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2- REMOVE TAB 3-Debur 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.050	6061-T6 .050 Sheet	.4968 sf (.0414 ea)	90-Waterjet - Flow - 1	5048658	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Waterjet - Flow - 1	M6061T6S.050	0	63	0	
Part Specifications					
Specifications could not be found.					

Plex 3/3/20 8:18 AM Dart.Renwick.Jennifer

SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203471



D5787-1 PLACARD
(DERIVED FROM AERO DESIGN P/N 77627-01 & P/N 94027-01)

UNDER REVIEW

URF 2020-525 20.02.20 (NO)

NOTES:

- 1) MATERIAL: 6061-T6/T62/T651 ALUMINUM SHEET OR PLATE, 0.050 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.3 AS SHOWN
USE 0.002-0.010 DEPTH AND MIN TOOL RAD OF 0.010
- 7) WEIGHT: 0.03 lbs
- 8) ENGRAVE DART LOGO AND ALL TEXT 0.002-0.010 DEEP WITH MIN TOOL RAD OF 0.010
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D5787-1 REV.A.STEP"

RELEASED

2020 FEB 19
ECN 2-40-524

APPROVED

A NEW ISSUE		MW	20.01.22
REV.	DESCRIPTION	BY	DATE
DESIGN	MW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5787	SHEET 1 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	PLACARD	NTS
DATE	20.01.22	COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR EXPOSED OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



873044

May 20, 2018 1:54 PM Post Office Box

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 07606/H.S. 050

PO / BATCH NO: 23906/0048653

DATE: MAR 07 2018

MATERIAL CERT REC'D: YES

THICKNESS ORDERED: .050

QUANTITY RECEIVED: 8000

THICKNESS RECEIVED: .050

QUANTITY INSPECTED: 8000

SHEET SIZE ORDERED: 4X12

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: 7X12

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y N	
CORRECT FINISH	Y N	
CORROSION	Y N	
CORRECT GRAIN DIRECTION	Y N	
CORRECT MATERIAL PER D-DRAWING	Y N	<u>0.0-4-250/11</u>
CORRECT THICKNESS	Y N	
PHOTO REQUIRED	Y N	
CORRECT REF # TO LINK CERT	Y N	<u>Heat# 32112/01</u>
CORRECT MATERIAL IDENTIFICATION	Y N	
CORRECT M# ON THE MATERIAL	Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: _____		
DATE: <u>07 MAR 07 2018</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: 6061-T6/T6 ALUMINUM SHEET

SPECIFICATION: QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS-4075 OR AMS-4027
OR ASTM B209

PART NUMBER: M6061T6S XXX
THK

WHERE "XXX" = SHEET THICKNESS (IN INCHES)

EG. 0.063" THICK SHEET = M6061T6S.063

PREFERRED SIZE XXX BY 4FT BY 8FT

RELEASED
2008-09-10

B	REFORMAT DWS 422 B209 SPEC (2N 07 13)	OP	09.07.13
A	NEW ISSUE	DS	01.09.08
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR			
APPROVED			
DE APPR			
DATE	09.07.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO: M6061T6S
REV 15
SHEET 1 OF 1
SCALE: NTS

6061-T6 SHEET SPEC

Copyright © 2005 by DART AEROSPACE LTD



DELIVERY - CLIENT

Copy CO00075982

ACIER OUELLETTE INC.

935, Bout. du Hêtre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4246 MB, 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 MB, 514-336-4246 Ext.: 866-450-4242

Customer N° CLI0001056
Date 2018/02/27
Delivery date 2018/03/06
Your order N° 39126
Processed by Josianne Bourdon
Salesman
Carrier OUELLETTE VALLEYFIELD
Credit Terme Net 30 Days
Page 5

Billed to
DART AEROSPACE LTD
1270, ABERDEEN ST.
HAWTHORNSHUR, Ontario, K0A 1K7

Shipped to
Ontario,
Att : CHANTAL LAVOIE Tél.: 613-632-5200

Instruction FM

Delivery Route S

Product Description	Weight	Qty	U/M	PCS NB			Internal Use Only					
				CMD	EXP	D/O	IN	I	S	C	OUT	
16 FLAT ALU 3/4 X 4 5001-T6 FAL 314 2596 1 X 12' HEAT: 70740	42.39	12.00	PL \$CLB		1X12'		12'				MAR 07 2018	
17 FLAT SS 3/4 X 2 1/2 SS304 RANDOM NS FSS 34212 N 8747 1 X 12' HEAT: 26800 NET 3597-MM-SS-03	229.50	36.00	PL \$CLB		2X12' 1X10' 10"		36'				MAR 07 2018	
18 ALU SHEET .051 (100) 5001-T6 (4 X 12) FAL 3514126861 3145 2 X 4 X 12' HEAT: 32115/01 TRANSIT ST JEROME LE 26/02	68.93	56.00	PL2 \$CLB		2X12'		96' 1/2				MAR 07 2018	

NIR : R-109515-6

Next Page...



ACIER OUELLETTE INC.

935, Brûlé du Hâvre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-567-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-356-4242

DELIVERY - CLIENT

Copy CO00075982

Billed to
DART AEROSPACE LTD
1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

Ontario

Att : CHANTAL LAVOIE Tél.: 613-632-5200

Instruction F.M

Delivery Route 5

Customer N° CL10001056
Date 2018/02/27
Delivery date 2018/03/06
Your order N° 39126
Processed by Josianne Bourdon
Salesman
Carrier OUELLETTE VALLEYFIELD
Credit Terms Net 30 Days
Page 5

Product Description	Weight	Qty	U/M	PCS HB			Internal Use Only				
				CM2	EXP	D/O	IN	I	S	C	OUT
16 FLAT ALU 3/4 X 4 6061-T6 PAL 3/4 2596 1 X 12' HEAT: 20740	42.29	12.00	PL_SCLB		1X12'		12'				MAR 07 2018
27 FLAT SS 3/4 X 7 172 B5304 RANDOM NS RSS 3/4 X 7 2947 2 X 12' HEAT: 20600 AC13057-4M-03-03	229.50	36.00	PL_SCLB		2X12' 1X10'		36'				MAR 07 2018
18 ALU SHEET 051 (16G) 6061-T6 (4 X 12) FEAL-0514126061 3145 2 X 4' X 12' HEAT: 32115/01 TRANSIT ST-JEROME LE 28/02	68.93	96.00	PI2_SCLB		2X4' X 12'		96' 1/2				MAR 07 2018

NIR : R-109516-6

Next Page...



Abnahmeprüfzeugnis 3.1 (EN 10204)
Inspection certificate - mill certificate

Nr.: 89051448
Rev.: 0

Seite / page: 1 von / of 2

Datum / date: 2017 05 29

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, ENAS 0100, ISO 14001, NADCAP

Warenempfänger / consignee: CBS Atlanta 1500 Cherokee Pkwy ACWORTH GA 30102-1603 USA	Bestell Nr. / order no.: 6400341710-R01
	Datum / date: 2017 02 23
	Auftragsbest. Nr. / order confirm no.: 127031
	Datum / date: 2017 02 24
	Lieferschein Nr. / delivery note: 89051448
	Datum / date: 2017 06 30

Produkt / product:	Bedingungen / terms:
Form / form: Sheet	Technische Lieferbedingungen / techn. spec.
Werkstoff / material: 6061	AMS-QQ-A-250/11, 08.1997
Zustand / temper: T6	ASTM B 208 - 14
Dim. / dim.: [inch] 0,050x46,00x144,00	AMS 4027N, 07.2008
Kundenartikel Nr. / cust. article no.: ALFLR01645	ASME SB-209, 2011a
	Sondervorschrift / special terms:

AB-Pos. ord.-item.	BHr/Los Lot/No.	Teillos Part	Guss Nr. cast no.	Werkstoff/ material	Kollo pack no.	Gewicht netto weight net	Stk. pcs.
03	32115/01	00	01/0082348/7	6061	1270310006	4001,323 lbs	119
03	32115/01	00	01/0083055/7	6061	1270310007	3877,072 lbs	119

Chemische Zusammensetzung [%] Gewichtanteile / Chemical composition [%] weight proportion (OES)												
Guss Nr. / cast no.	material	Si	Pb	Cl	Mn	Ni	Cr	Zn	Ti	Others Each	Others Total	
01/0082348/7	6061											
	spec. min.	0,40	-	0,15	-	0,80	0,04	-	-	-	-	
	spec. max.	0,80	0,70	0,40	0,15	1,20	0,35	0,25	0,15	0,05	0,15	
	actual	0,66	0,40	0,26	0,13	0,98	0,17	0,05	0,03	0,02	0,03	
01/0083055/7	6061											
	spec. min.	0,40	-	0,15	-	0,80	0,04	-	-	-	-	
	spec. max.	0,80	0,70	0,40	0,15	1,20	0,35	0,25	0,15	0,05	0,15	
	actual	0,35	0,39	0,23	0,17	0,87	0,17	0,06	0,03	0,01	0,03	

Zugprüfung LT / tensile test LT									
BHr/Los Lot/No.	Zustand temper	Richtung direction	Tests		UTS [ksi]	YS [ksi]	A2 ⁺ [%]		
				spec.min	42,0	35,0	10		
				spec.max	-	-	-		
32115/01	T6	LT	2	from	45,8	35,5	17		
32115/01	T6	LT		to	46,0	35,8	17		

AK 166V

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					